## Work Order ID 52129-Z



Page 1

Insp.

September 16, 2009 2:31:04 PM Item ID: D2917-2 Accept Setup Start Revision ID: B Item Name: Saddle RH Stop Start Date: 09/30/2009 Start Qty: 10.00 Cust Item ID: Required Date: 10/05/2009 Reg'd Oty: 10.00 Customer: Reference: Run Start Process Plan: MF Date: 09-09-16 Tooling: Approvals: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Reject Work Center ID Description **Run Hours** Number Rev. Code Qty Qty Number Stamp Draw Nbr Revision Nbr D2917 Rev B 100 0.00 HAAS CNC VERTICAL MACHINING #1 HAAS 1 Memo HAAS CNC vertical machine #1 Program batch number Machine Step No 1 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet Machine Step No 2 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 3 as per Folio 110 0.00 CONVENTIONAL MILLING MACHINE

Mill Conv

Conventional Milling Machine

Memo

Machine Keyway and inspect per Dwg D2917 & attached dimension shee

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

0.00

		*		

## Work Order ID 52129

September 16, 2009 2:31:04 PM



Page 2

Item ID:

D2917-2

Required Date: 10/05/2009

Revision ID: B

Item Name: Saddle RH

Start Date:

09/30/2009

Start Qty: 10.00

Req'd Qty: 10.00



Accept



Cust Item ID:

Customer:

Draw

Setup Start



Stop

Reference:

Process Plan: Approvals:

QC:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ **Run Hours** 

0.00

Plan Draw Number Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

0

140



Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

0.00

10 00-10-8

BR 09-10-8

150 Powdercoat

Powder Coating

White Gloss(Ref:4,3.5.1) per QSI005 4.3-Alum

START TIME:

OVEN TEMPERATURE:

## Work Order ID 52129

Page 3

September 16, 2009 2:31:04 PM

Item ID:

D2917-2

B

Revision ID:

Item Name: Saddle RH

Start Date:

09/30/2009

QC:

Start Qty: 10.00 Required Date: 10/05/2009

Reg'd Qty: 10.00



Accept



Setup Start





Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Run

Start

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3-Inspect Part Finish

Memo

Set Up/ Run Hours

SPC (Y/N):

0.00

09/10/08

Draw

Number Rev.

Draw

Plan

Date:

Accept Code Qty

Reject Qty

Reject Number Stamp

Insp.

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

1916

## **Picklist Print**

September 16, 2009 2:31:04 PM

Work Order ID: 52129

Parent Item:

D2917-2RevB

Parent Item Name: Saddle RH



Start Date: 09/30/2009

Required Date: 10/05/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Primary Item Location Last Location

Route Seq ID Unit of Measure

Qty on Hand

Remaining Qty To Pick Issued Date Issued

Status

D6102-010RevD

Comments:

Manufactured

No

100

Each

6.0000

10.0000

Saddle Billet

Warehouse

Loc Oty

Loc Code

Location

Main Warehouse

MAT

51423

Qty

Page 1

	2

DART AEROSPACE LTD	Work Order:	52129
Description: Saddle RH	Part Number:	D2917-2
Inspection Dwg: D2917 Rev. A1	- 1-1-1-1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Re	corded Act	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.175	0.205		.195	.197	,192	.195		
В	0.090	0.110		.095	-100	.100			
С	0.250	0.270		. 265	.267	.262	.267		
D	1.599	1.619		1.614	1.615	1.610	1.614		
E	0.180	0.220		-180	.180	.130	180		
F	0.277	0.297		.285	.284	.238	. 284		
G	1.385	1.400		1.391	1.395	1.390	1.390		
Н	3.170	3.230		3,200	3.200	3,200	3.200		
1	0.175	0.217		.137	3.200	. 191	191		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.503	1,503	1.503	1.503		
L	4.436	4.446		4.438	4.438	1.503	4.438		
M	0.257	0.262	DT8683	.259	.259	.259	.259		
N	1.225	1.235		1.228	1.224	1.228	1.228		
0	1.103	1.113		1.106	1.106	1,106	1.106		
Р	0.470	0.530		1500	500	.500	.500		
Q	0.438	0.443	DT8682	.440	.440	.440	.440		
R	0.490	0.510		:508	502	,502	.500		
S	1,745	1.755		7.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	3.00	8.00		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		. 200	.200	ZOS	200		
W	1.990	2.010		2.000	2.008	2.004	2.003		
X	0.760	0.765		.760	.760	.761	1761		
Y	0.307	0.312	_	310	.310	.3//	311		
Z	0.615	0.635		.628	.624	.625	.625		
AA	0.177	0.197		138	1/85	.184	-135		
AB				1100	1,00	7.07	703		
AC									
AD									
AE			EWES .						
AF									
AG									
AH									

0 8	
Measured by: 8/1	Audited by
Date: 09/10/05	Date: polin lol.

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM 1.A	-1
В	04.09.20	Added DT8683 & DT8682	KJ/JLM KJ	941

		89

DART AEROSPACE LTD	Work Order:	52129
Description: Saddle RH	Part Number:	D2917-2
Inspection Dwg: D2917 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 and record below:

			Ke	corded Act	ual Dimension	15	-1-1	
Min	Max	Go/No Go Gauge	5*	6 2	74	4	Ву	Date
0.175	0.205		-136	.197	.196	17 12 18		
0.090	0.110		-100	110	110			
0.250	0.270		,258		.263			
1.599	1.619			1.610	1.614			
0.180	0.220		-184					
0.277	0.297		.246		.285			
1.385	1.400		1.390		1.393			
3.170	3.230			3.200	3.200			
	0.217		,191	.175				
0.470	0.530	<b>1</b>	,500	.500	,500			
1.498	1.508			1.503	1503			
				259				
				1.230				
				1.108				
				-500				
				.440	440			
					605			
			- August and a second		8.000			
					3,500			
				1205				923
	2.020		2.000	2,004				
	0.765			.71.6				
					. 628			
	0.197				.181.			
		They are			TO DATE OF			
					F-725			
			1300	THE R	C. West of			
THE DE				Paul mark	2002			
			Table 1					
					J 5			
	0.175 0.090 0.250 1.599 0.180 0.277 1.385 3.170 0.175	0.175         0.205           0.090         0.110           0.250         0.270           1.599         1.619           0.180         0.220           0.277         0.297           1.385         1.400           3.170         3.230           0.175         0.217           0.470         0.530           1.498         1.508           4.436         4.446           0.257         0.262           1.225         1.235           1.103         1.113           0.470         0.530           0.438         0.443           0.490         0.510           1.745         1.755           7.990         8.010           3.495         3.505           0.175         0.205           2.000         2.020           0.760         0.765           0.307         0.312           0.615         0.635	Min         Max         Gauge           0.175         0.205         0.090         0.110           0.250         0.270         1.599         1.619           0.180         0.220         0.277         0.297           1.385         1.400         3.170         3.230           0.175         0.217         0.470         0.530           1.498         1.508         4.446           0.257         0.262         1.225         1.235           1.103         1.113         0.470         0.530           0.438         0.443         0.443         0.490         0.510           1.745         1.755         7.990         8.010         3.495         3.505           0.175         0.205         2.000         2.020           0.760         0.765         0.307         0.312           0.615         0.635	Min         Max         Gauge         5 h           0.175         0.205         ./86           0.090         0.110         ./00           0.250         0.270         .258           1.599         1.619         ./610           0.180         0.220         ./84           0.277         0.297         .266           1.385         1.400         ./390           3.170         3.230         3.200           0.175         0.217         ./71           0.470         0.530         .500           1.498         1.508         ./503           4.436         4.446         ./440           0.257         0.262         .259           1.225         1.235         ./230           1.103         1.113         ./28           0.470         0.530         .500           1.745         1.755         ./750           7.990         8.010         .500           3.495         3.505         .750           0.175         0.205         .204           2.000         2.020         2.000           0.760         0.765         .760	Min         Max         Gauge         5 h         6 h           0.175         0.205         .186         .177           0.090         0.110         .100         .110           0.250         0.270         .258         .362           1.599         1.619         .660         .660           0.180         0.220         .784         /80           0.277         0.297         .366         .385           1.385         1.400         .370         /391           3.170         3.230         3.200         3.200         3.200           0.175         0.217         .191         .75           0.470         0.530         .500         .500           1.498         1.508         .503         .503           4.436         4.446         9.990         .257         .259           1.225         1.235         1.230         1.230         1.230           1.103         1.113         1.108         1.108         1.108           0.470         0.530         .500         .500         .500           0.438         0.443         .940         .940         .940           0.490	Min         Max         Gauge         5 P         6 A         13           0.175         0.205	Min         Max         Gauge         5         6         7         7           0.175         0.205         ./36         .17         .176           0.090         0.110         ./00         ./10         ./10           0.250         0.270         .258         .363         ./619           1.599         1.619         ./610         ./610         ./614           0.180         0.220         ./84         /80         ./81           0.277         0.297        266        385        285           1.385         1.400         ./.390         /.391         ./.343           3.170         3.230         3.200         3.200         3.200           0.470         0.530        503        503        500           1.498         1.508        503        503        503           1.498         1.508        503        503        503           1.255         1.235        230        230        230           1.103         1.113        108        108        108           0.470         0.530        500        500        500 <td>Min         Max         Gauge         5 7         6 2         7 3         8 3           0.090         0.110         100         110</td>	Min         Max         Gauge         5 7         6 2         7 3         8 3           0.090         0.110         100         110

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	Date: e	7/00/05	Date:	04/0/07	
_	D-4-	Channe		Revised by	Approved
Rev	Date	Change		Revised by	Approved
A	04.08.12	New Issue		KJ/JLM	Approved
A B		The state of the s			Approved

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DART AEROSPACE LTD	Work Order:	52129
Description: Saddle RH	Part Number:	D2917-2
Inspection Dwg: D2917 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 and record below:

			Re						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.175	0.205		190	190	-190	777	17	
В	0.090	0.110		-090	.093	. 090	A.		
C	0.250	0.270		-268	.267	-267			
D	1.599	1.619		1.617	1.1017	1.617			
E	0.180	0.220		.180	.180	-180			
F	0.277	0.297		-292	-292	.293			
G	1.385	1.400		1.388	1.388	1.388			
Н	3.170	3.230		3.190	3.191	3.191			
1	0.175	0.217		.177	.179	-180			
J	0.470	0.530		.500	.500	.500			
K	1.498	1.508		1.499	1.503	1.503			
L	4.436	4.446		4.440	4.440	4.440			
M	0.257	0.262		.259	.259	.259			
N	1.225	1.235		1.227	1.226	1.229			
0	1.103	1.113		1.105	1.106	1.108			
P	0.470	0.530		.500	500	-500			
Q	0.438	0.443		440	.446	.440			
R	0.490	0.510		.502	.503	-504			
S	1.745	1.755		1.750	1.749	1.750			
T	7.990	8.010		8.006	8.003	8.001			
U	3.495	3.505		3,500	3.500	3.500			
V	0.175	0.205		.205	-205	205		14.54	- 100
W	2.000	2.020		2.002	2.000	2.001	100		1
X	0.760	0.765		760	-766	740			
Υ	0.307	0.312		.311	-766	-3/1			WHITE I
Z	0.615	0.635		-624	-626	.625			
AA	0.177	0.197		. 185	-186	.185	الأقرباء وا		
AB							P. Contract		
AC					Let 1				
AD							Front.	10.7	
AE									44
AF					74				
AG					Tro				
AH									
	Acc	ept/Reje	ct						The second

Measured by:	ant.	Audited by	m=
Date:	09/10/06	Date:	27/10/07

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM	7 14
В	04.09.20	Added DT8683 & DT8682	KJ/JLM , A	
C	09.09.14	Revised dimension W	KJ KJ	18

Dart Ae	rospace	Ltd							
W/O:			WO	RK ORDER CHANGES	6				
DATE	STEP	PF	Ву	D	ate Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect		
								<i>3</i> 2.	
	5 ×4		W. 81						
Part No	):	PAR #:	Fault Cate	gory:	NCR: Yes	s No	DQA:	Date:	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NC	R)	1		
		Description of NC	Corrective Action Section B			Verif		Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	8	Section C	Chief Eng	QC Inspec
						4			
					3			1	
	100								

NOTE: Date & initial all entries

